

*Rush*

Date: Wednesday, 21/05/2008 1:53:51 PM  
User: Melanie Fauteux

**Process Sheet**

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	GUIDE
<b>Job Number</b> :	39373		
<b>Estimate Number</b> :	12705		
<b>P.O. Number</b> :		<b>Part Number</b> :	D35723
<b>This Issue</b> :	21/05/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3572 REV.C
<b>First Issue</b> :	1/1	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	38324	<b>Drawing Revision</b> :	
	<b>Type</b> :	<b>Material</b> :	
	MACHINED PARTS	<b>Due Date</b> :	26/05/2008
<b>Written By</b> :		<b>Qty:</b>	16
<b>Checked &amp; Approved By</b> :	<i>MF</i>	<b>Um:</b>	Each
<b>Comment</b> :	Est Rev:A New Issue 07-02-07 JLM est rev B rev.B dwg EC		

**Additional Product**

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6B0500X01000	6061-T6 Bar .50" x 1.0"
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*0.04100*



**Comment:** Qty.: 0.0893 f(s)/Unit Total: 1.4280 f(s)  
6061-T6 Bar .500" x 1.00 *.750 x 1.500*  
Batch: *M108118*

*mf 08/05/24*

*(16)*

2.0	M6061T6B0625X01500	6061-T6 Bar .625" x 1.5"
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**Comment:** Qty.: 0.5000 f(s)/Unit Total: 8.0000 f(s)  
6061-T6 Bar .625" x 1.5"

*mf*

*30*

3.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW  
Cut blank 1.500" long

*mf 08/05/24*

*(16)*

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA685 Rev: *AA* & Dwg D3572 Rev: *C*

2-Deburr per dwg D3572

*mf 08/05/25*

*(16)*

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

*mf 08/05/25*

*(76)*

Date: Wednesday, 21/05/2008 1:53:52 PM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 39373

Part Number: D35723

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

08/05/26 (16)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CALL

08/05/26 (16)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/27

Job Completion



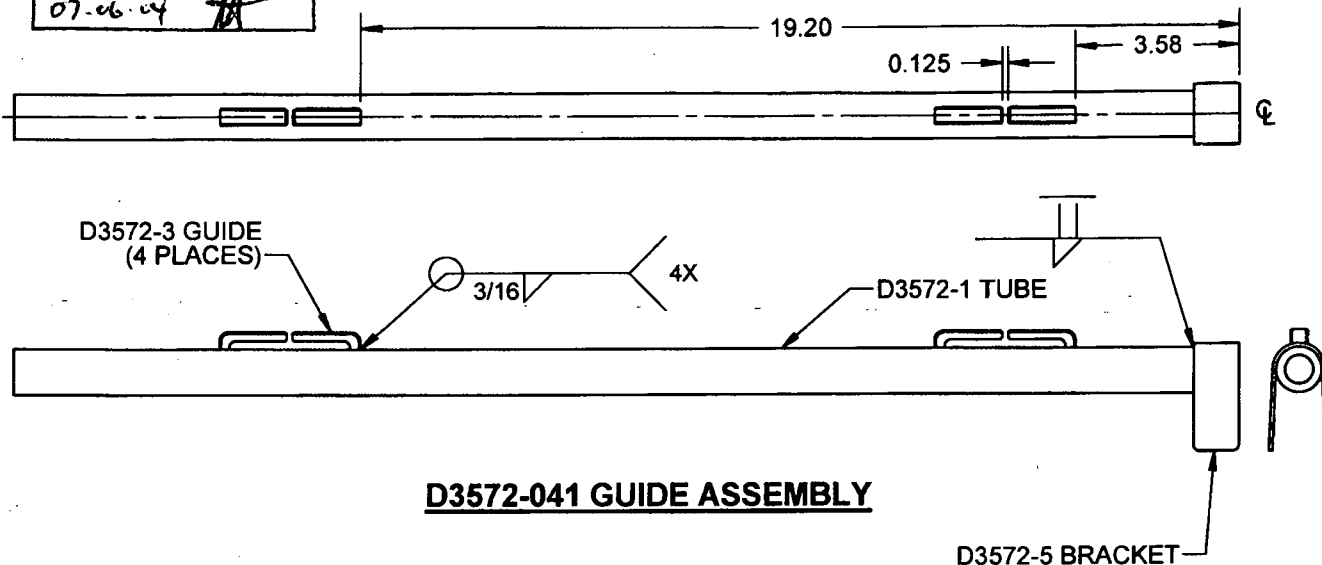
MF 08-05-26



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3572</b>	REV. C SHEET 1 OF 2
DATE <b>07.06.01</b>	TITLE <b>GUIDE ASSEMBLY</b>		SCALE 1:4
REV	DATE	DESCRIPTION	
A	07.03.29	NEW ISSUE	
B	07.04.20	FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET	
C	07.06.01	REMOVE D3572-7	

**RELEASED**

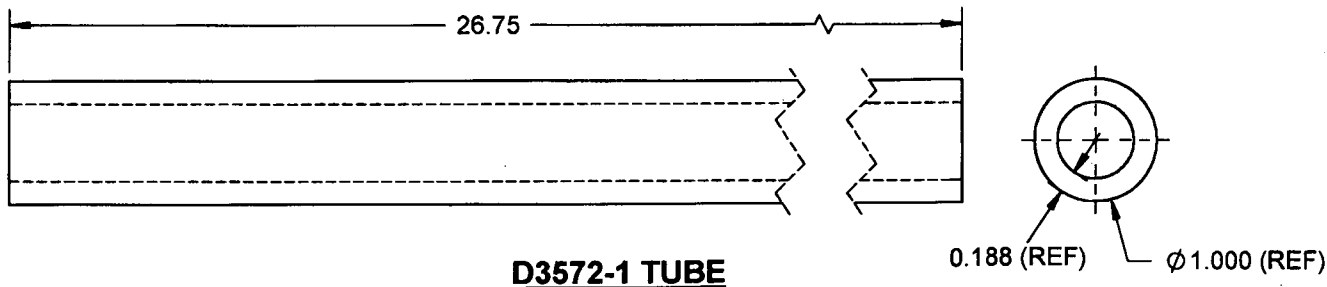
07.06.01 *H*



**D3572-041 GUIDE ASSEMBLY**

**D3572-041 NOTES:**

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3572-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) WELD PER DART QSI 004



**D3572-1 TUBE**

**D3572-1 NOTES:**

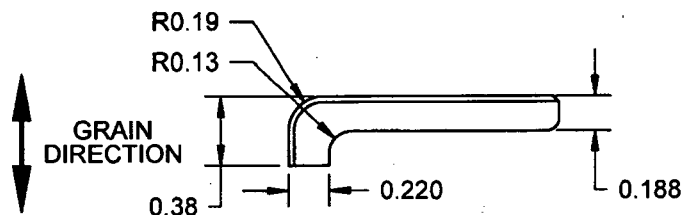
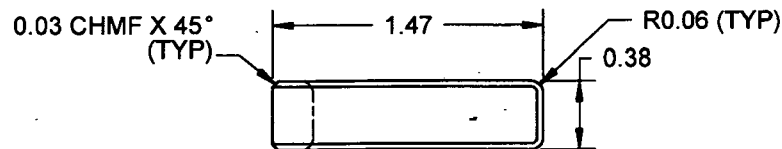
- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8  
(REF DART SPEC M6061T6T1.000W.188)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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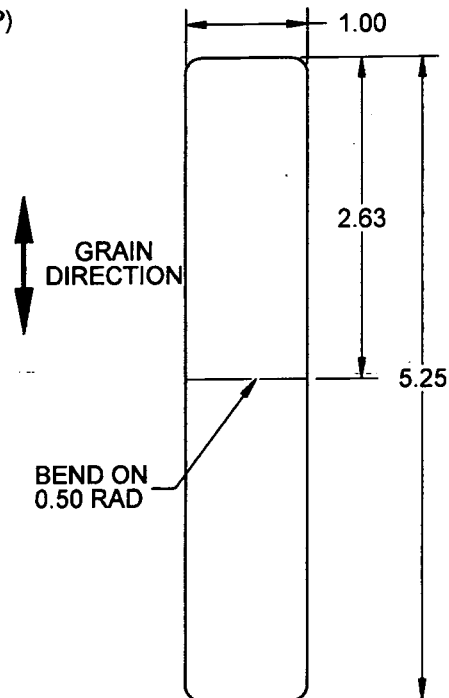
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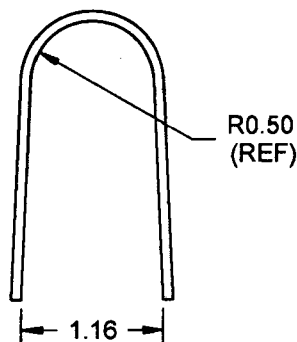
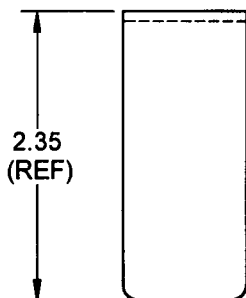
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3572</b>	REV. C SHEET 2 OF 2
DATE <b>07.06.01</b>		TITLE <b>GUIDE ASSEMBLY</b>	
		SCALE 2:3	



**1 D3572-3 GUIDE**



**2 D3572-5F FLAT PATTERN**



**D3572-5 BRACKET  
(MAKE FROM D3572-5F)**

**RELEASED**

07.06.01 *H*

**D3572-3/-5 NOTES:**

- 1) D3572-3 MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR  
PER QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6B)
- 2) D3572-5 MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11  
OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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